Work Order I September-23-13 11			*107309*								,	Page 1		
Item ID: D30 Revision ID: Item Name: Rap	)11-1 pel			Accept	*N900040100* Setup Star					IA	14.21			
Start Date: 9/23/13 Start Qty: 4.00 Required Date: 9/23/13 Req'd Qty: 4.00 Reference:		*4* *4*			Cust Item ID: Customer:									
	ocess Plai	n:	Date: <i>B-04-25</i>	Tooling: SPC (Y/N):			ate:		I	Run Sta Sta	IV	R1* R2*		
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hour	<b>S</b>	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp		
Draw Nbr D3011	Revi	ision Nbr		0.00										
*100* Bandsaw		BAND SAW  Memo Cut Blank	s: 26.625"	0.00	and f	13/01/	] 3b		4	B _				
110				0.00			<b>,</b>						<b>7</b>	
*110* HAAS 1 HAAS CNC vertical mac	hine #1	HAAS CNC VERTICA  Memo  Machine a	as per folio FA129	0.00	b.a	13/10/	02		_4			У.В.	10-03	
•		Folio Rev Dwg Rev									, <b>2</b>	770-	フ	

\*\*\*ENSURE SURFACES ARE SMOOTH, BUFF ALL SCRATCHES AS REQUIRED AS PER NOTE 11 DWG D3011\*\*\*

NCR:	Yes	/	No

## WORK ORDER NON-CONFORMANCE / UPDATE

l h	~t .l.u	ľ	
DQA XXX L	Date: <u>63(11/14</u>	P	
A Closed:	Date: 12/1(//)		

										QA CIOSCO.	$\sim 11  \text{V}$		
Work Order:	105	7/19	;		DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. <u>D</u> 301/-1 NCR No. <u>13-3199</u>					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube  Machining X Small Fab  Thermoforming Finishing  Large Fab Composite			4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root				Descri	ption of work order update		nitial	Act	ion	Sign &			
Cause	Date	Step	Qty		or Non-conformance		ief Eng	i e	iption	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	13/10/03	4		found that on al Pand RC. Inst was wor	durking to deburni Meratu touches sine. With Bond saw. traction on Folio Followers	Q)	0AS 16 9-89	High Street Pant Scrap Scrapt Pe Replace	or. Pstm'		mL 13/10/04	DAS 16 9-89 Q)2042 (3/10/03	
			•		F	AUL	T CATE		1				
Landing	Gear				General								
	Bending Centre No	ot Conce	ntric to	o/s	Bend BOM/Route	Н	Grain Hardwa			Ovalized Over/Under	<del></del>	Pressure/Forced Temperature/Cure	
	Cracks Crushed/	Crimped			Broken/Damaged Burrs		Instruc	ion Incomplete tions Incomplete/U	Jnclear	Part Incorre		Weld Wrong Stock Pulled	
-	Cuffs Contamination Heat Treat Countersink				┪	$\vdash$	Mainte Mislabe	enance eled		Part Moved Positioned V	Vrong		
1	Inspectio	Inspection Strip in Tube Cut Too Short					Misrea	d		Power Loss/	Surge X	Other	
Ripples in Bend Drill Holes					Offset			instruction		ouea			
Torque Waves in Extrusion Drawing					Out of Calibration								
Turning Sequence Finish					Out of Sequence								
Wave/Twist in Tube Folio							Outside Dimensions						

Work Order	ID	107309
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\*107309\*

Page 2

September-23-	13 1,1:4/:39	AM									
Item ID: Revision ID:	D3011-1			Accept	*N900	040	100	<b>)*</b> s	etup Star	i Vi	S1*
Item Name:	Rappel								Stop	, *N	S2*
Start Date:	9/23/13	Start Qty: 4.00	*4*		Cust Item 1	D:					
Required Date	e: 9/23/13	<b>Req'd Qty:</b> 4.00	*4*		<b>Customer:</b>						
Reference:											
Approvals:	Process P	lan:	Date:	Tooling:	D:	ate:		R	Run Star	17	R1*
	QC:		Date:	<b>SPC (Y/N):</b>	Da	ate:			Stop	, *N	R2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		QC2- Inspect parts off m	achine FAI/FAIB	0.00							
*120*								4	B		1/3-10
QC Quality Control		Memo		0.00						·	
Carring 11 and											
130		QC8- Inspect parts - seco	and check	0.00	Con/13/1	dry					
*130*						, ,		4	e		
QC		Memo		0.00							
Quality Control					·						
131		•		0.00				./	1.		
*131*								24/10	my		
Outsource2		Memo	TD 1077/11151	0.00							
Outsource process	- NDT		ER ASTM 1417 LEVE te of conformity is requi	L 2 AS PER DWG D3011 red							

Po 21819

NCR: Y	res /* No				WORK ORDER NON-	CON	IFORN	MANCE / UP	DATE					
	•			•						QA Closed:	Date	<u>.</u>		
Work Orde	er:				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part N					Rework Scrap		Skid-tube Crosstube  Machining Small Fab			<b>=</b>	Water Jet d. Eng. Coor.	Engineering Quality		
NCR N	No				Use-as-is Work Order Update	Thermoforming Finishing Rec/Store/Packaging Large Fab Composite Supplier					Other			
Root Descri					ption of work order update	lr	nitial	Ac	ction	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	cription	Date	Verification	QC Inspector		
Doc/Data		Ì												
Equip/Tooling						1								
Operator														
Material						1								
Setup														
Other						1		:						
Process				1		1		ĺ						
Supplier		į	1			į.				i				
Training											·			
Unapproved														
					F	AUL	T CATE	GORY						
Landi	ng Gear				General					_		_		
	Bendin	g			Bend		Grain		_	Ovalized	<u></u>	Pressure/Forced		
	Centre	Not Conce	entric to	O/S	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure		
	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct [	Weld		
	Crushe	d/Crimped	l		Burrs		Instruct	tions Incomplete	/Unclear	Part Lost/M	ssing	Wrong Stock Pulled		
	Cuffs				Contamination		Mainte	enance		Part Moved				
	Heat T	eat			Countersink		Mislabe	eled		Positioned V	Vrong	_		
	Inspec	ion Strip ir	ո Tube		Cut Too Short		Misread	d		Power Loss/	Surge	Other		
	Ripples	in Bend			Drill Holes		Offset							
Torque Waves in Extrusion Drawing							Out of	Calibration						

Out of Sequence

Outside Dimensions

DQA:

Date:

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Turning Sequence

Wave/Twist in Tube

Finish

Folio

V	Vork	Order	ID	10	730	19
▼.	UIR	Oluci	11/	IV	/ J U	,,

September-23-13 11:47:40 AM

### \*107309\*

Page 3

D3011-1 Accept \*N900040100\* Item ID: Setup Start **Revision ID:** Stop Item Name: Rappel \*4\* **Start Date:** 9/23/13 Start Qty: 4.00 **Cust Item ID:** Required Date: 9/23/13 Req'd Qty: 4.00 **Customer:** Reference: Run Start Process Plan: Date: **Tooling: Approvals:** Date: Stop Date: SPC (Y/N): QC: Date: Sequence ID/ Operation Set Up/ **Tool ID** Reject Tool # Plan Accept Reject Insp. **Work Center ID** Description Number Stamp Code Qty Qty **Run Hours** 132 Receive & Inspect for Damage & Mat'l Certs 0.00 \*130\* 0.00 Packaging Memo Packaging QC5- Inspect part completeness to step on W/O 135 \*135\* QC Memo Quality Control 140 Chemical Conversion Coat per QSI005 4.1 0.00 4 7813-10-29 \*140\* HandFinish 0.00 Memo Hand Finishing

DQA: Date:
------------

NCR: Yes / No

#### **WORK ORDER NON-CONFORMANCE / UPDATE**

										QA Closed:	Dat	te:	
Work Ordei					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No	o				Rework Scrap Use-as-is Work Order Update	Machining Small Fab Prod. Eng. Coor.  Thermoforming Finishing Rec/Store/Packaging					Quality Other		
Root Description of work order upd							itial	Δ.	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	1	ef Eng		ription	Date	Verification	n QC Inspector	
Doc/Data	Dute	Step	۵.,		or real communes	1	C1 2.1.8	200				. Qo mapeotor	
Equip/Tooling						1							
Operator										!			
Material	<b>-</b>						•						
Setup													
Other													
Process													
Supplier		ļ											
Training													
Unapproved					•								
					F	AULT	CATE	GORY					
Landin	g Gear				General					_	_		
	Bending				Bend		Grain			Ovalized		Pressure/Forced	
	Centre No	ot Conce	ntric to (	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorred	ct	Weld	
	Crushed/	Crimped		L	Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs				Contamination		Mainte	enance		Part Moved			
	Heat Trea	at			Countersink		Mislabe	eled		Positioned V	Vrong		
[	Inspectio	n Strip in	Tube		Cut Too Short		Misread	t		Power Loss/	Surge	Other	
[	Ripples in	Bend			Drill Holes		Offset						
	Torque W	/aves in E	extrusion	n _	Drawing		Out of 0	Calibration					
	Turning S	equence			Finish		Out of 9	Sequence					
Wave/Twist in Tube Folio					1 4	Outside Dimensions							

Work Orde September-23-1.				*107				Page 4					
Item ID: Revision ID: Item Name:	D3011-1 Rappel			Accept	*N900040100*			*	Setup	Start Stop		S1* S2*	
Start Date: Required Date: Reference:	9/23/13 Start Qty: 4.00 9/23/13 Req'd Qty: 4.00		*4* *4*		Cust Item ID:								
Approvals:	Process Plan:QC:		Date:	Tooling: SPC (Y/N):					Run	Start Stop	*NR1* *NR2*		
Sequence ID/ Work Center II 150 *150* Powdercoat Powder Coating	D	Operation Description White Gloss(Ref.4.3.5.1)  M/26/25  Memo START TIM OVEN TEM FINISH TIM	e/li <b>45</b> Perature: 30°	Set Up/ Run Hours 0.00	Tool ID		Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp	DAS 34 9-89
*160 *160* QC Quality Control		QC3- Inspect Part Finish  Memo		0.00				4x		<del></del>		13/	

170

Identify as per dwg & Stock Location

0.00

\*170\* Packaging

Memo

0.00

Packaging

4x

13/1/01985

										DQA:	Date	:	
NCR: Y	es / No				WORK ORDER NON-C	ONF	ORN	ANCE / UPDA	ATE	•			
								_		QA Closed:	Date	:	
Work Orde	r:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
Part N NCR N	o				Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Water Jet Machining Small Fab Prod. Eng. Coor. Thermoforming Finishing Rec/Store/Packaging Supplier					Engineering Quality Other		
Root				Descri	ption of work order update	Ini	tial	Actio	n	Sign &			
Cause	Date	Step	Qty	(	or Non-conformance	Chie	f Eng	Descrip	tion	Date	Verification	QC Inspector	
Doc/Data							ļ						
Equip/Tooling							Ì						
Operator													
Material			Į.										
Setup							·						
Other [			İ										
Process													
Supplier													
Training						1							
Unapproved		<u> </u>											
					F	AULT	CATE	GORY					
Landir	ng Gear				General								
	Bending				Bend	G	rain			Ovalized	L	Pressure/Forced	
	Centre No	ot Concei	ntric to	o/s	BOM/Route	Н	ardwa	re		Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged	In	specti	on Incomplete		Part Incorred	it _	Weld	
	Crushed/	Crimped			Burrs	In	structi	ions Incomplete/Un	clear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs				Contamination	$\square$ N	1ainte	nance		Part Moved			
	Heat Trea	at	Countersink					led		Positioned Wrong			
	Inspection Strip in Tube Cut Too Short					Misread Power Loss/Surge Other					Other		
	Ripples in Bend Drill Holes					o	Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Work Ord September-23-				*107	7309*							Page	5
Item ID: Revision ID: Item Name:	D3011-1 Rappel		-	Accept	*N9000	140°	100	)* s	•	art top	*N:	S1*	
Start Date: Required Date Reference:	9/23/13 e: 9/23/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item ID: Customer:	:							
Approvals:	Process P QC:	Plan:	Date:	Tooling: SPC (Y/N):	Date Date		· · · · · · · · · · · · · · · · · · ·	I		tart top	*NI *NI	R1* R2*	
Sequence ID/ Work Center 180 *180* QC Quality Control	ID	Operation Description QC21- Final Inspection Memo	- Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty ML	Reject Qty	N	Reject Number	Insp. Stamp	<b>o</b> -01

				DQA:	Date: _	
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE			*

						-					QA Closed:	Date	•
Work Orde	er:					DISPOSITION	AGAINST DEPARTMENT/PROCESS						
Part N	- . ۱۵۰					Rework Scrap Use-as-is Work Order Update		Machining Small Fab Prod. Eng. Coor. C					Engineering Quality Other
Root					Descri	ption of work order update	li li	nitial	Ac	ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data								-					
Equip/Tooling													
Operator													
Material													
Setup		ı											
Other							1						
Process													
Supplier													
Training													
Unapproved			<u> </u>										
						F	AUL	T CATE	GORY				
Landi	ng (	Gear			-	General		ı			-		<b></b>
		Bending			L	Bend		Grain			Ovalized	_	Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route	Ш	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	<u> </u>	Cracks				Broken/Damaged	Ш	Inspect	ion Incomplete		Part Incorred	it _	Weld
		Crushed/	'Crimped			Burrs	Щ	Instruct	ions Incomplete/	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs			<u> </u>	Contamination	Ш	Mainte	enance		Part Moved		
	L	Heat Trea	at			Countersink	-	Mislabe			Positioned V	· · ·	_
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	t		Power Loss/	Surge	Other
	$ldsymbol{ld}}}}}}$	Ripples in				Drill Holes	1	Offset					
	<u></u>	Torque W	Vaves in I	Extrusio	n	Drawing	$\vdash$		Calibration				
Turning Sequence Finish				Out of 9	Sequence								
İ	Wave/Twist in Tube Folio			1	Outside	Dimensions							

September-23-13 11:47:39 AM

Work Order ID:

107309

Parent Item:

D3011-1

Parent Item Name:

Rappel

**Start Date:** 9/23/13

Required Date: 9/23/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP C02.05.09Added D6202 at step 2NG

IPP Rev:D Added QC8 JLM Verified By:EC

IPP REV:E 13.06.26 AS PER

DWG REV.C DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6202 I-Beam Extrusion		Manufactured	No			110	f	36.0000	2.1666	9.1225264			
				<b>Location</b>		Loc Qty	<u>Lo</u>	c Code					
				MAT028		36						,	, ,
				10461	13	25			9	1.13	SM	-131	09/2
				10547	74	11							حب , ح

		~									DQA:	Date:	
NCR:	Yes	/ No				<b>WORK ORDER NON-</b>	COI	NFORM	<b>JANCE / UPI</b>	DATE		_	
											QA Closed:	Date:	:
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Ordi	٠	· · · · · ·				Rework	<b>]</b>		Skid-tube	Crosstube	]	Water Jet	Engineering
Part I	۷o.					Scrap		ſ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	_	i .	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	No.					Work Order Update	ل		Large Fab	Composite	J	Supplier	
Root					Descri	otion of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ct	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data	Ш												
Equip/Tooling													
Operator							1						
Material	Ш												
Setup				1			Ì						
Other	Ш												
Process	Ш												
Supplier										-			
Training			į										
Unapproved													
							FAUI	LT CATE	GORY				
Landi	ing (	Gear				General		_			_	·	_
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to C	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	Г	Inspecti	on incomplete		Part Incorre	ct	Weld
	Г	Crushed/	Crimped		i	Burrs	Г	Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Г	Cuffs	-			Contamination		Mainte	nance		Part Moved		<del></del>
		Heat Trea	at			Countersink		Mislabe	led		Positioned V	Vrong	
	Г	Inspectio	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	Surge	Other
		Ripples in	n Bend			Drill Holes		Offset		<del></del>	***	<b></b>	

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	107309
Description: Rappel Slide Bar	Part Number:	D3011-1
Inspection Dwg: D3011-1 Rev: C		Page 1 of 1

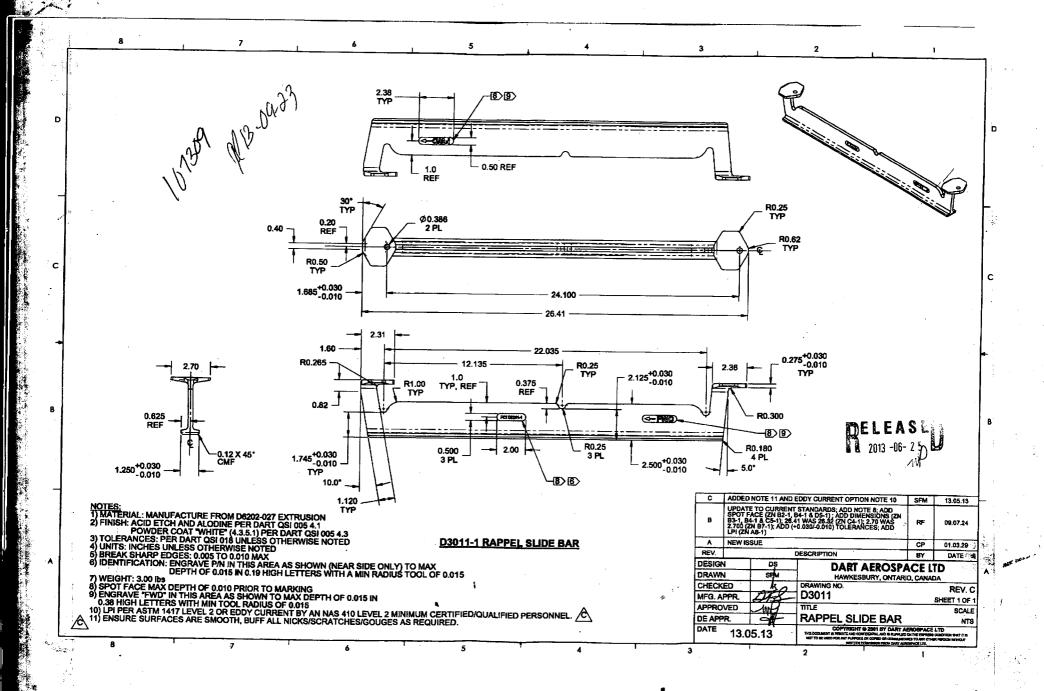
## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.41	+/-0.030	2641			motapo	
2.31	+/-0.030	2308			Vern	0-الـ
2.36	+/-0.030	2360			-	
1.120	+0.030/-0.010	1-120	/		-	
1.685	+0.030/-0.010	1-686			^	
1.745	+0.030/-0.010	1.756	/		`	
1.250	+0.030/-0.010	1268		***************************************		
2.500	+0.030/-0.010	2516			^	
2.125	+0.030/-0.010	2140			-	
0.275	+0.030/-0.010	277			÷	
0.375	REF	2341			J-G	
Ø0.386	+0.006/-0.001	388			~	
						,

Measured by:	Audited by:	and	Preliminary Approval:	
Date: 13-10-03	Date:	13/10/04	Date:	

Rev	Date	Change	Revised by	Approved
Α	09.05.04	New Issue	KJ/DD	
В	09.09.14	Dimensions revised per Dwg Rev B	KJ 10	
С	13.07.18	Dwg Rev updated	KJ C	

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		Section 1
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			1,			1/2	<i>.</i> : <i>.</i>	~ ~	
	San San San San San San San San San San	3	K	VS	$\leftarrow$		/.[(	<u> </u>	
				J	_				
				_	Air	trave	el. Ev	oived	١.

SKYM046-18 Rev 1 Apr/12

# NDT Work Order

Pottoling 5mp

Air travel. Evolved. Sky Service F.B.O. Inc.	DOT ADD 52 00 / EACA	145.7142 / BDA AMO 385
WO #: YYZ  Make:  70248  Customer: DART REPOSPACE Dept  Model:  CSN:  TSO	t: NDT YYZ Refe g: A/	rence: 21819 C S/N:
Task:   ✓ ScheduledUnscheduledA.O.G.   ✓ P.T  Work Requried:	M.TE.T.	U.TR.T.
CARRY OUT NOT ON FOUR (4) T	PAPPELS I	A.W
DART WORK ORDER # ID 107309 - I	ITEM# D30	11 - 1
		,
Action Taken:	Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION	240eT 2013	DOT APP 19 53-89
CARRIED OUT ON FOUR (4) RAPPELS		
TTEM # D3 OII-1 IAW ASTM 1417 REV.		
No CRACKS FOUND		
		* Walled
ARDROX 970825E LOT# 021/03101		
B/L # M Z 9189		
certified that the maintenance described above has been performed with the applicable standard	ACA/SCA Stamp	Date:
Name: GARY Sm 1 TH	DOT -APP 19 53 89	24 oct 13

	Billion and Maria and Carlot State Committee					
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